



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2962-190
Job Sheet 207256



5264 504

Part No: D2962-190

Job Qty: 40 pcs

MAR 18 2020

Part Name: Extrusion



Part Weight: 0 lbs

Job Created: 2/20/20

Due Date: 3/13/20

Type: Stock

Note: DWG REV B

Ship Via:

Status: New

Priority: Medium

Job Tracking No:

Created By: Kimberley Guerin

Description:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	40 pcs	3/13/20		0.00	0.00	Purchasing - 1		DAS 82
							Purchasing - 2		89
							Purchasing - 3		MAR 18 2020
110	Packaging 2-1 - Receive - B4B	40 pcs	3/13/20		0.00	40.00	Packaging 2 - 1 - B4B		
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		DAS 82
							Packaging 2 - 13 - B4B		9-89
							Packaging 2 - 14 - B4B		MAR 18 2020
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 -		

Plex 2/20/20 3:37 PM Dart.Guerin.Kimberley

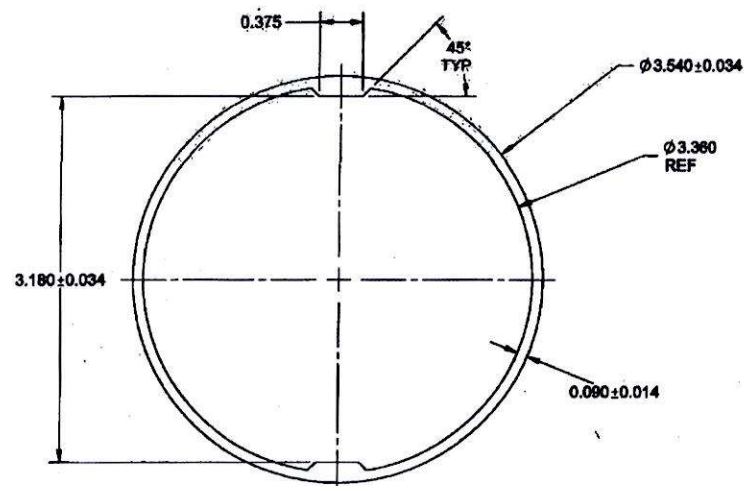
						B4B	
						Packaging 2 - 21 - B4B	
						Packaging 2 - 22 - B4B	
						Packaging 2 - 23 - B4B	
						Packaging 2 - 24 - B4B	
						Packaging 2 - 25 - B4B	
						Packaging 2 - 26 - B4B	
						Packaging 2 - 27 - B4B	
						Packaging 2 - 28 - B4B	
						Packaging 2 - 29 - B4B	
						Packaging 2 - 30 - B4B	
						Packaging 2 - 31 - B4B	
						Packaging 2 - 32 - B4B	
						Packaging 2 - 33 - B4B	
						Packaging 2 - 34 - B4B	
						Packaging 2 - 35 - B4B	
						Packaging 2 - 36 - B4B	
						Packaging 2 - 37 - B4B	
120 QC 6	40 pcs	3/13/20	0.00	0.00		QC 6 - 9	68-6
						QC 6 - 68	78
						QC 6 - 61	SVD
						QC 6 - 40	MAR 23 2020
						QC 6 - 81	
130 Packaging 3-1 - Stock - B4B	40 pcs	3/13/20	0.00	0.00		Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Plex 2/20/20 3:37 PM Dart.Guerin.Kimberley	

				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS 21 9-89 MAR 3 1 2020
				Packaging 3 - 37 - B4B	
140 QC 21 - SA	40 pcs	3/13/20	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	DAS 21 9-89 MAR 3 1 2020
				QC 21 - SA - 53	
Part Op 100 - (Purchasing) Descriptions: 110 - (Receive & Inspect for Damage & Mat'l Certs) 120 - (QC6- All purchased or subcontracted products) 130 - (Identify as per dwg & Stock Location: _____) 140 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D2962-190P	Extrusion	40 pcs (1 ea)	100-Purchasing	5264502	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Purchasing	D2962-190P	40	0	0	
Part Specifications					
Specifications could not be found.					

D2962-190P

LINE
2

8 7 6 5 4 3 2 1

DAS
82
9-89RELEASED
2013-06-21
APL

NOTES:

- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM PER AMS-QQ-A-200/8 (OR AMS 4180) OR ASTM B221
 MINIMUM YIELD TENSILE STRENGTH = 35 ksi
 MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi
 MINIMUM ELONGATION = 8%
 A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES.

- 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.016 TO 0.025 MAX
 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.1
 7) WEIGHT: 0.105 lb/in
 8) MANUFACTURED USING BON L CANADA DIE # DAA-3
 9) NO TOOLING MARKS
 10) ORDER AS D2962-XXX WHERE XXX = LENGTH IN INCHES
 EG. 125 LONG: D2962-125

B	UPDATE FORMAT AND EXTRUSION TOLERANCES	SFM	13.05.09
A	NEW ISSUE	RF	00.03.10
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE USA, INC	
DRAWN	SFM	KENT, WA	
CHECKED	A.P.	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D2962	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	EXTRUSION	NTS
DATE	13.05.09	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC THIS DOCUMENT IS UNCLASSIFIED, UNCONTROLLED, AND IS RELEASED BY THE COMPANY UNDER THE FACT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR REPRODUCED TO ANY OTHER PERSON OR ENTITY WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1

Guillaume Gamache-Beauchamp

From: Patrick Duval
Sent: 16 mars 2020 15:08
To: Guillaume Gamache-Beauchamp
Subject: FW: Guillaume QC6

FYI

Pat Duval

From: Patrick Duval
Sent: March 16, 2020 2:15 PM
To: Michelle GagnonDonovan <mgagnondonovan@dartaero.com>; 'Marie Lajeunesse (mlajeunesse@dartaero.com)' <mlajeunesse@dartaero.com>; Zoe Evans (zevans@dartaero.com) <zevans@dartaero.com>; 'Shannon Hadley (shadley@dartaero.com)' <shadley@dartaero.com>
Cc: Marcel Daviau <mdaviau@dartaero.com>; Jason Leroux <jleroux@dartaero.com>; Serge Carriere (scarriere@dartaero.com) <scarriere@dartaero.com>; Valerie Miller <vmiller@dartaero.com>
Subject: Guillaume QC6

All
I have received & reviewed the training from Guillaume Gamache-Beauchamp regarding his inspection levels for QC6 and he is competent to perform this inspection levels.

Zoe,
Please adjust his training recorded to show that he has completed his training. (Stamp 82)

Shannon,
Please add the appropriate work center

Pat Duval
QC Coordinator

DART AEROSPACE
T: 1-613-632-5200 ext.228
www.dartaero.com
pduval@dartaero.com





Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB045811



Supplier: SIG001-VC
Signature Aluminum Canada Inc.
C/O/ T10322C
PO Box 4488, STN A
TORONTO
ON
M5W 4H1 Canada
Phone: 905-427-6550
Fax: 905-427-2246

PO No: POHB045811
PO Date: 2/7/20
Due Date: 3/11/20
Purchase Order Revision:
Revision Date:
Issued By: Lavoie, Chantal
Phone: 613-623-5200 Ext: 242
Fax: 613-632-1053
clavoie@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 30

Freight Terms:
Special Comments: quote no. 02062020-006

Items

Line Item	Job	Part	Drawing	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	206748	D2962-150P	D2962		3.540 Outer Tube, Extrusion : AS PER DWG D2962 REV. B DIE # DAA-3 150" LONG EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE OUTSIDE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS	Firmed	-	3/11/20	88 pcs	0 pcs 82 PLS	88 pcs	\$39.56162/pcs	\$3,481.42
2	207256	D2962-190P	D3672	DAA-3	Extrusion as per DWG D2962 Rev B - 190" long EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF TUBE MATERIAL MUST BE SMOOTH AND FREE FROM DEFECT SCRATCHES, NICKS and DENTS	Firmed	-	3/11/20	40 pcs	0 pcs 44 PLS	40 pcs	\$50.0717/pcs	\$2,002.87
												Grand Total:	\$5,484.29

K. Guerin



Dart Aerospace Ltd.
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Hawkesbury, ON
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Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB045811



Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY
A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Plex 2/21/20 10:08 AM Dart.Guerin.Kimberley



DRIVER

**SIGNATURE ALUMINUM CANADA**1850 CLEMENTS RD
PICKERING, ON L1W 3R8**CERTIFICATE OF COMPLIANCE**

2

Cert Date	Cert No.	Sales Order	Page
03/13/2020	5573312	139335	1
Cust PO	B/L No	Lot	Date
POHB045811	047175	933692	03/16/20

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA

Item No	Part No	Item Description	Cust Part
002	DAA-3-3	190" MILL 6061 T6 ✓	D2962-190P 190"MILL6061T6 ✓

Gross Weight	935 LBS
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Net Qty	877 LBS	44 PCS	2 PKGS
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Specification	Die Desc
AMS QQA 200/9 + ASTM B221-08 ✓	

Mechanical Tests:

Tensile	Yield	% Elongation	Conductivity	HRE
MPA / KSI	MPA / KSI			
297.3 / 43.1 ✓	259.3 / 37.6 ✓	10.1 ✓	N/A	91

Chemical Analysis:

Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	V	Zr
0.62	0.27	0.20	0.07	0.87	0.06	0.06	0.02	0.01	0.00

DAS
82
8-89*This Material is Made in Canada**This Material is RoHS Compliant*

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

S. Gooder
Quality Manager
Signature Aluminum Canada Inc

ISO 9001/TS16949 Registered Company

Visit us at www.signaturealum.com

Rev A

